

EXHAUST EJECTOR, JACKET, ASSY, LHS REPAIR SCHEME

MODEL: BELL 212, 412, 412CF & 412EP

Read all of the repair instructions thoroughly
prior to the repair of this product



Applicability

The Repair Scheme, as defined herein, and the Exhaust Ejector Jacket Assy, Repair Kit is applicable to the following item.

<u>Item</u>	<u>Part No</u>	<u>Description</u>	<u>Serial No</u>
1	AAL-061-207-001	Jack, Assy, LHS	All

General Notes

1. The Repair Scheme, as defined herein, is the Alpine Aerotech Ltd. (AAL) authority to repair the item(s) referenced within this document.
2. All Repair Instructions shall be accomplished in accordance with standard aircraft practices unless otherwise specified. Refer to the current revision of the FAA manual AC 43.13, Aircraft Inspection, Repair & Alterations, for instructions.
3. All Hardware and Fasteners shall be installed IAW standard aircraft practices. Refer to the current revision of the FAA manual AC 43.13, Aircraft Inspection, Repair & Alterations, for instructions.
4. All Dimensions are in imperial measures (inches/pounds).
5. Refer to the current revision of the Exhaust Ejector/Deflector, Maintenance Manual Supplement (MMS-AA212-061-201) for the inspection requirements of the item(s) referenced within this document.
6. All Rivet Callouts and Rivet Codes are specified as follows.

<p>BASIC CODE</p> <p>D=DIMPLE C=C'SNK #=SHTS AFFECTED</p>		<p>DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE</p>	<p>BASIC CODES</p>
		<p>DASH NO. FOR LENGTH W=SPOTWELD OPTIONAL EXISTING</p>	<p>BF=MS20427M()-()</p> <p>LN=MS20615-()M()</p>



Repair Notes

- 1 Apply Sealant (Item 11) to faying surface, 100% Coverage, Max .020 Total Thickness.
- 2 Apply fillet of Sealant (Item 11) on all edges.

Repair Instructions

1. Place masking tape on the inner surface of the Jacket, Assy, LHS to mark the locations of the existing Refrasil Tape, Details as required. Remove the rivets and washers retaining the existing Refrasil Tape, Detail, AFT as shown. Remove and disregard all existing Refrasil Tape, Details. Reference Figure 1.

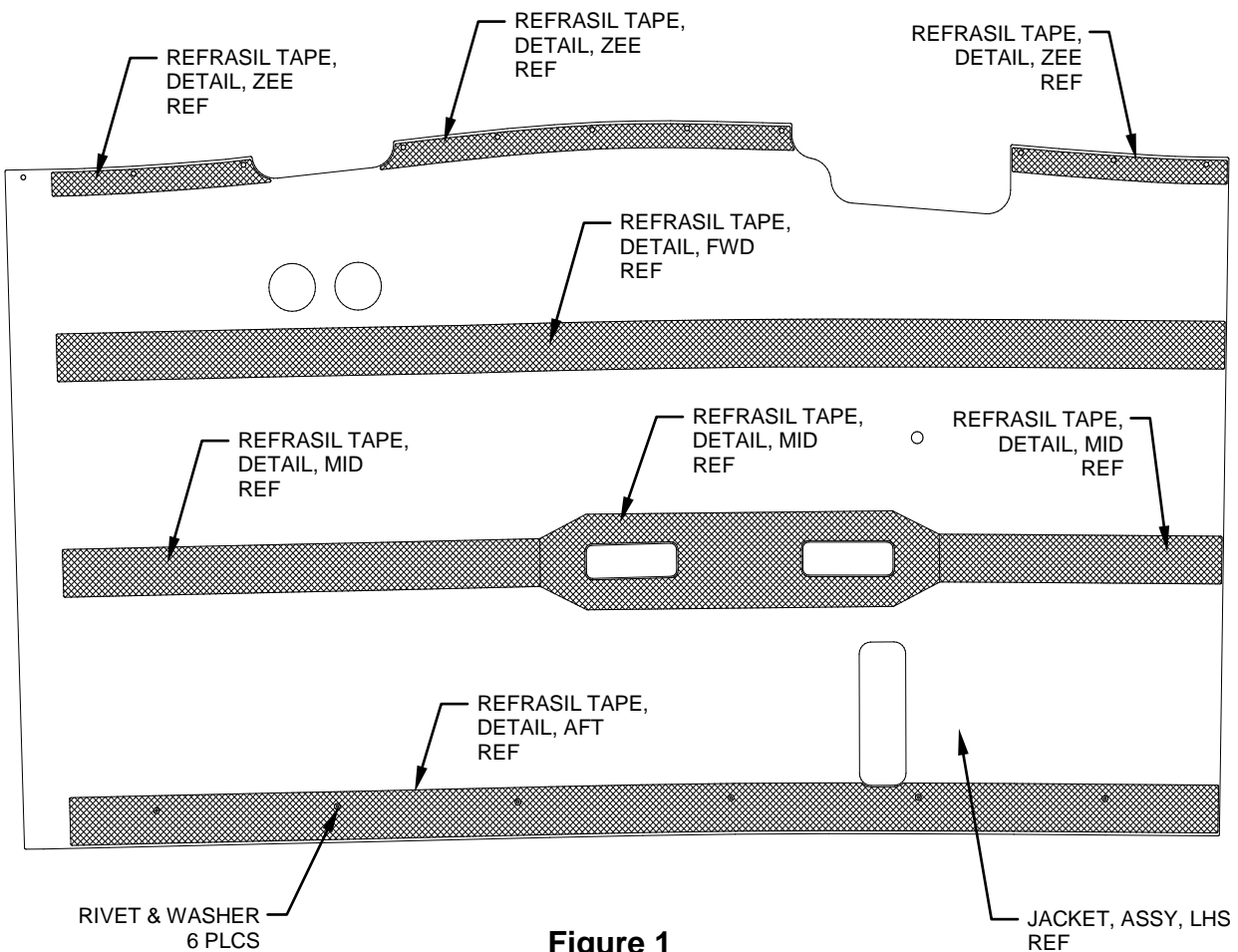


Figure 1

VIEW LKG AT INNER SURFACE OF JACKET, ASSY, LHS
FLAT PATTERN SHOWN FOR CLARITY



Repair Instructions

2. Remove the rivets retaining the existing Wear Strip, Detail as shown. Remove and disregard the existing Wear Strip, Detail. Reference Figure 2.

NOTE: Removal of existing Wear Strip, Detail is NOT mandatory if its present condition is acceptable.

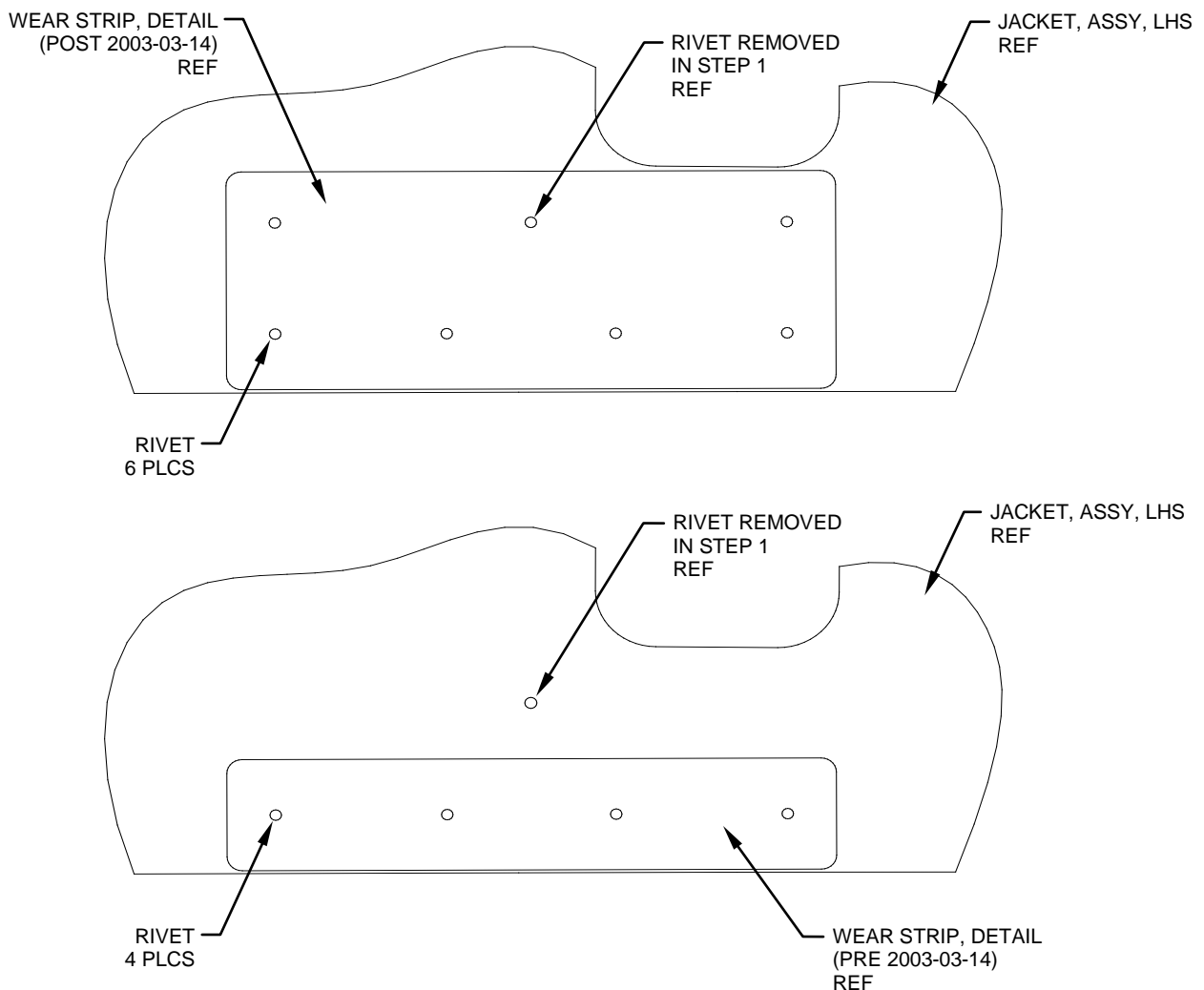


Figure 2

VIEW LKG AT OUTER SURFACE OF JACKET, ASSY, LHS
FLAT PATTERN SHOWN FOR CLARITY
(POST & PRE 2003-03-14 CONFIGURATIONS SHOWN)



Repair Instructions

- If applicable, clean the faying surface of the new Wear Strip, Detail (Item 1 or 2 as applicable) and Jacket, Assy, LHS with Xylene.
- If applicable, install the new Wear Strip, Detail (Item 1 or 2 as applicable) and rivet in position as shown. Reference Figure 3.

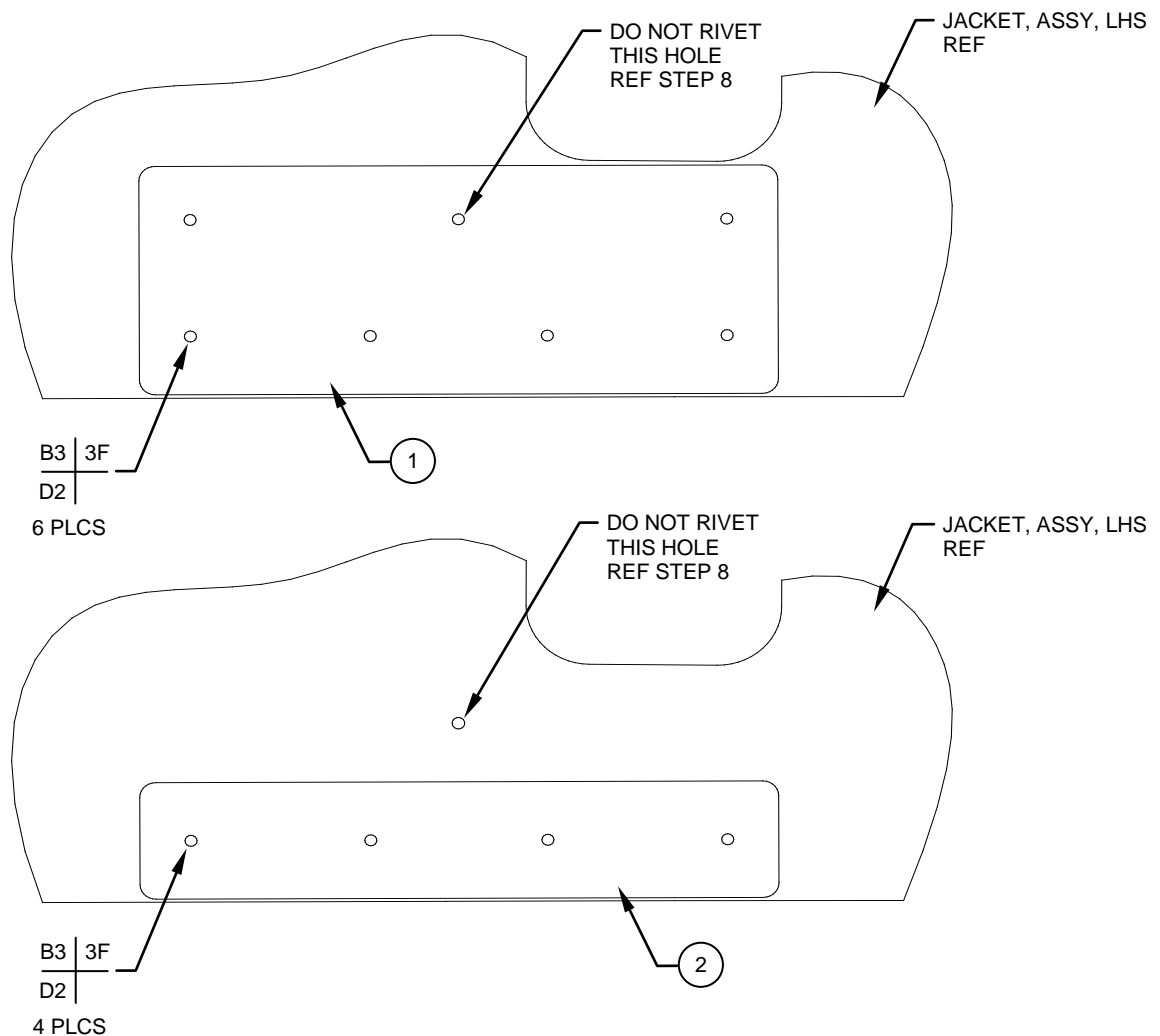


Figure 3

VIEW LKG AT OUTER SURFACE OF JACKET, ASSY, LHS
FLAT PATTERN SHOWN FOR CLARITY



Repair Instructions

5. Lay the Jacket, Assy, LHS flat and clean the faying surfaces with Alcohol.
6. Apply the Sealant (Item 11) to the faying surfaces of Refrasil Tape, Details (Item 3, 4, 5, 6, 7, 8, 9, 10). Reference Figure 4.
7. Adhere the Refrasil Tape, Details (Item 3, 4, 5, 6, 7, 8, 9, 10) to the Jacket, Assy using the masking tape installed in step 1 as a reference. Apply a fillet of Sealant (Item 11) around all Refrasil Tape, Detail edges as shown. Remove and disregard the masking tape installed in step 1. Allow the Sealant to fully cure. Reference Figure 4.

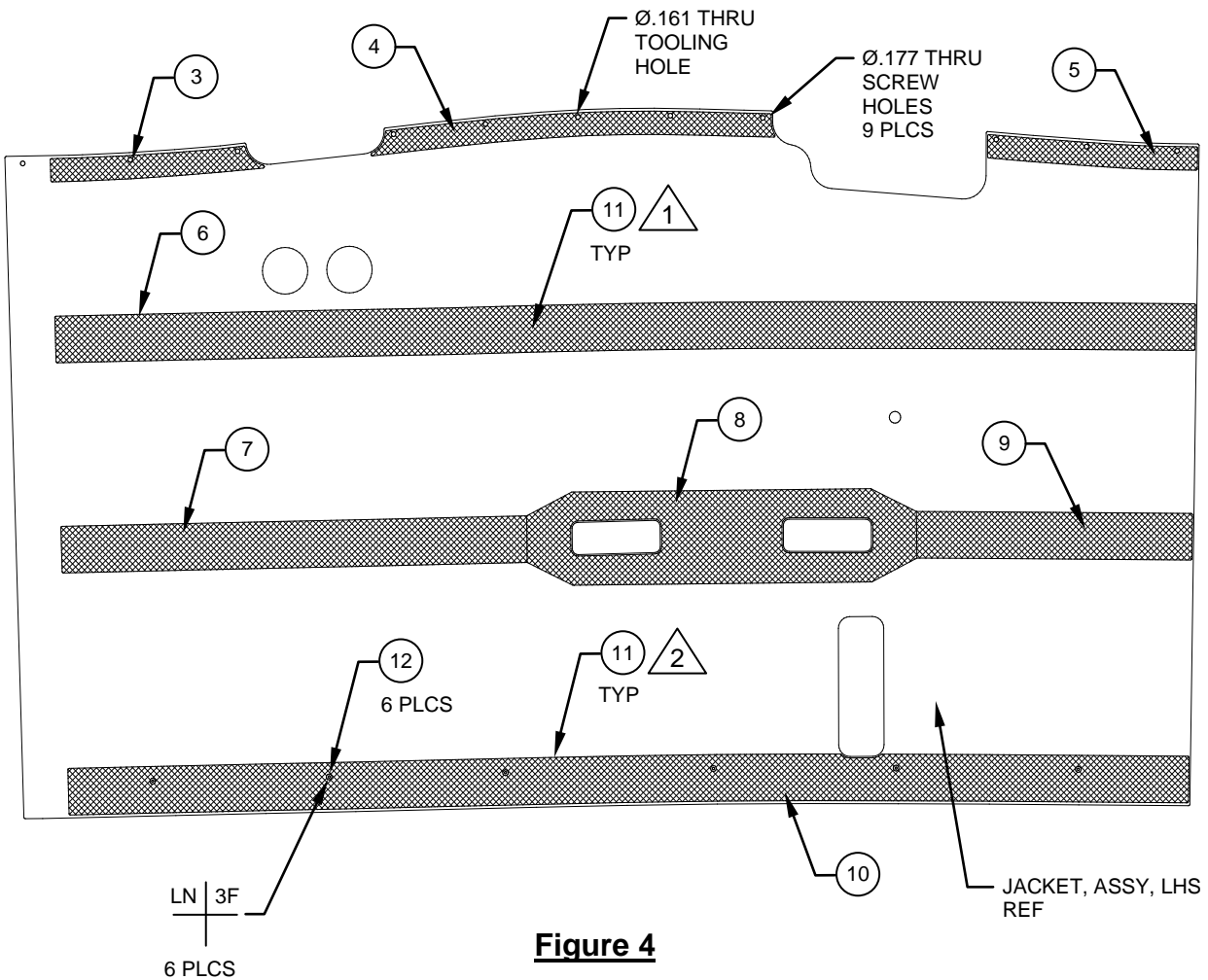


Figure 4

VIEW LKG AT INNER SURFACE OF JACKET, ASSY, LHS
FLAT PATTERN SHOWN FOR CLARITY



Repair Instructions

8. Back drill the Jacket, Assy, LHS rivet holes into the Refrasil Tape, Detail, AFT (Item 11). If applicable, back drill the Wear Strip, Detail (Item 1) rivet hole into the Refrasil Tape, Detail, AFT. Rivet the Refrasil Tape, Detail, AFT in position as shown. Reference Figure 4.

NOTE: Ensure rivet Washers (Item 12) are installed on the Refrasil Tape side.

9. Back drill the Jacket, Assy, LHS tooling hole and screw holes into the Refrasil Tape, Details (Item 3, 4, 5) as shown. Reference Figure 4.

NOTE: Ensure center tooling hole is drilled the proper size (Ø.161).

10. Clean the entire Jacket, Assy, LHS with Xylene.

NOTE: Ensure Xylene does NOT contact the Refrasil Tape, Details.

11. Repairs complete.
12. Perform a general inspection on all repairs to ensure proper integrity and security.
13. Update the aircraft log book for the repair of the subject item.

